

Date: Tuesday, 31/03/2009 1:02:32 PM
 User: Julie Dawson

Process Sheet

SH 01-9

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number : 46727	
Estimate Number : 10254	
P.O. Number :	Part Number : D212664101
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D212-664-141 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 46726	Material :
Written By :	Due Date : 20/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUL 09-03-31</u>	
Comment : Est Rev:E 04.02.16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Comments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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CY09/04/13

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

5 09/04/13

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D212664101TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-46200

MB

09-04-01

①

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

MB

09-04-01

①

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

P 09.04.06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 46727

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

fm 09-04-07 (1)

AWM 9-4-7 (1)

fm 09-04-07 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 9-4-7



(1)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80964107 (x)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8537

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C209104108 (1)

C2/4/8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

80964109 (x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 46727

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 12:30

Finish Time: 1:30

RT 09-04-08

PAINT:

Start Time: 4:30

Finish Time: 5:30

13.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

8/04/09 (R)

14.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support 42353

RT 09-04-09

15.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.2000 Each(s)/Unit Total : 4.2000 Each(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: 43210

RT 09-04-09

16.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25 Clamp 109955

RT 09-04-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 46727

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 111249
Expiry Date: 10-02-01

BT 09-04-09

3-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 09.04.13 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-04-13 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: B-39675

92448

CU

21.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

CU

22.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109832

CU 7/4/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 46727

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M110704

24.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M108183

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

27.0

QC21

FINAL INSPECTION/W/O RELEASE

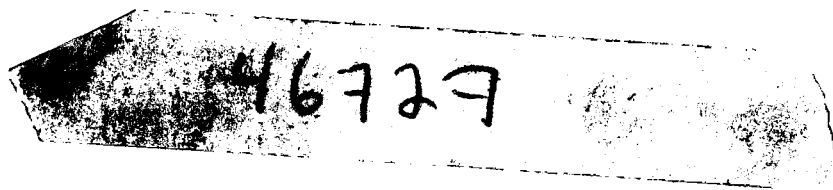


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-13



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

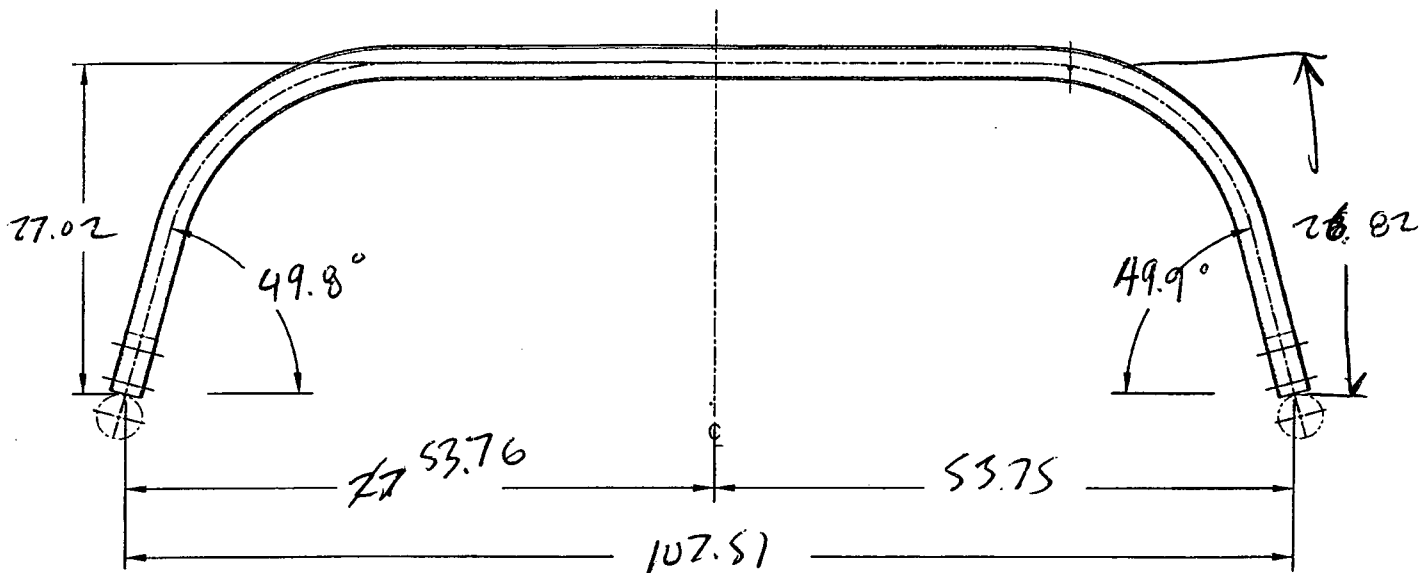
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46727	
Description: Crosstube High Fwd (205/212/412)	Part Number: D212-664-101	
Inspection Dwg: D212-664-141	Rev: C	Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	09.04.06
Date	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED PH	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED07.04.24 **PH**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

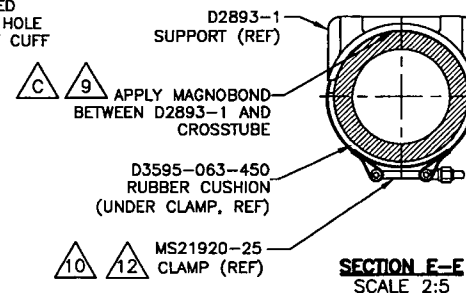
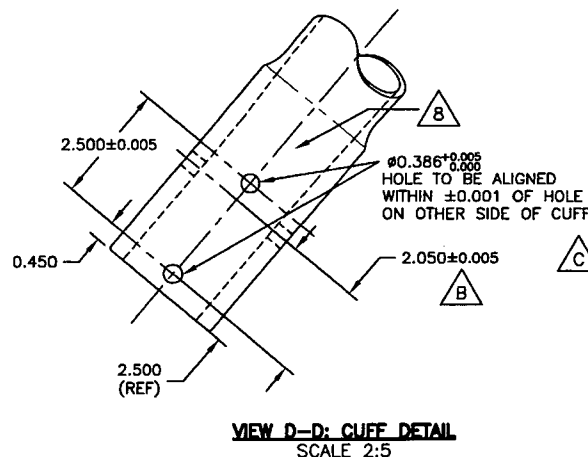
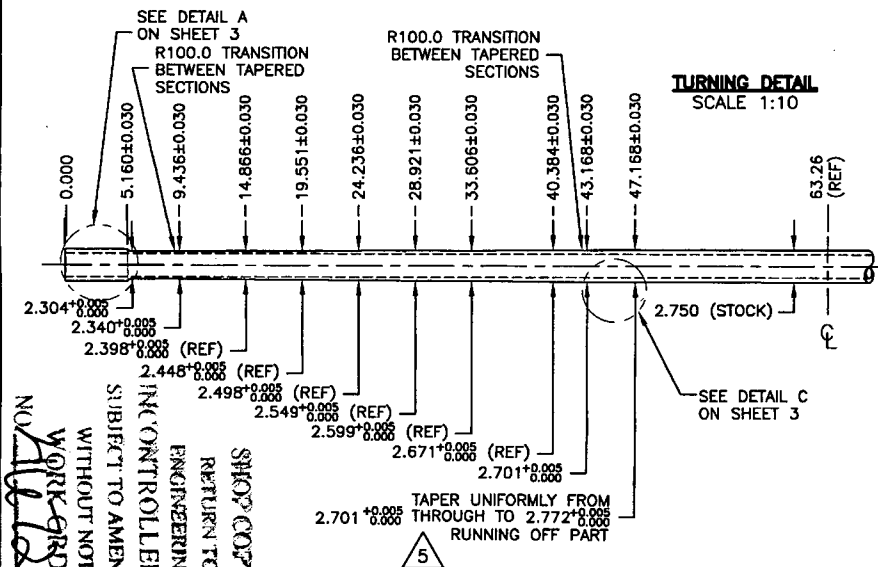
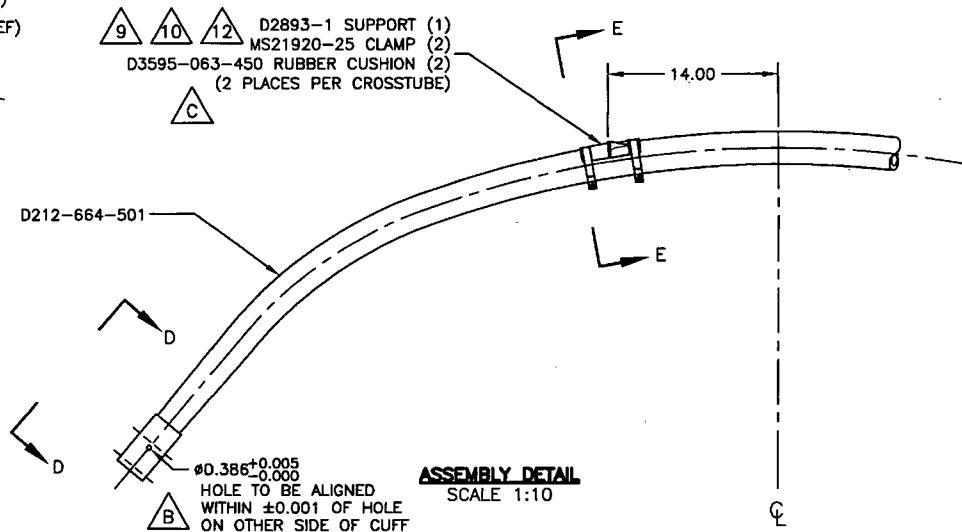
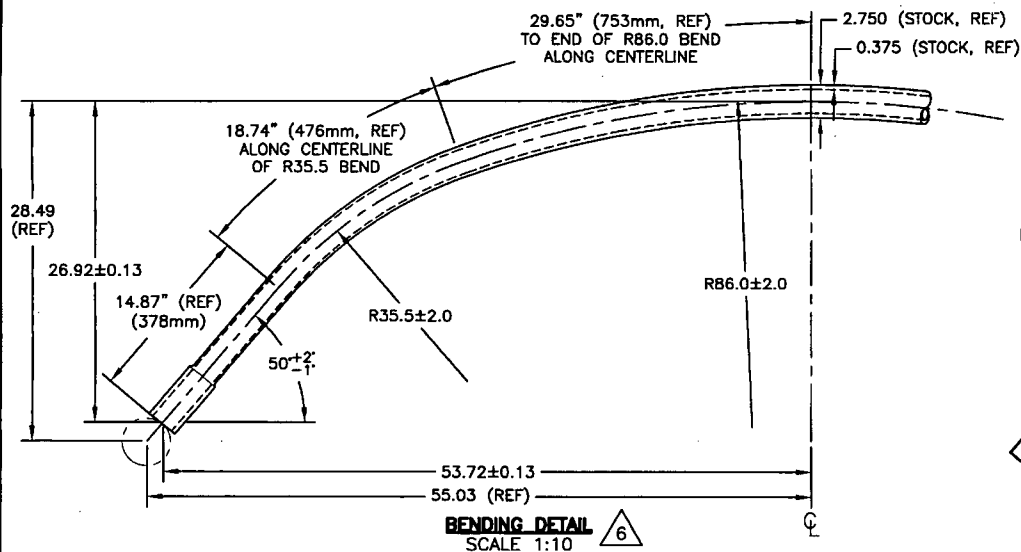
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. **40121**

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07.04.24

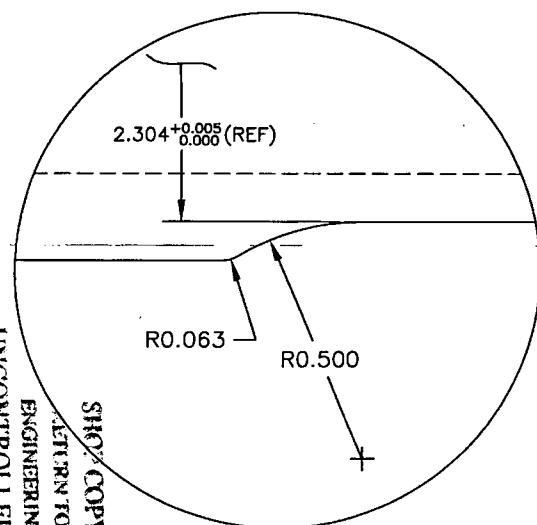
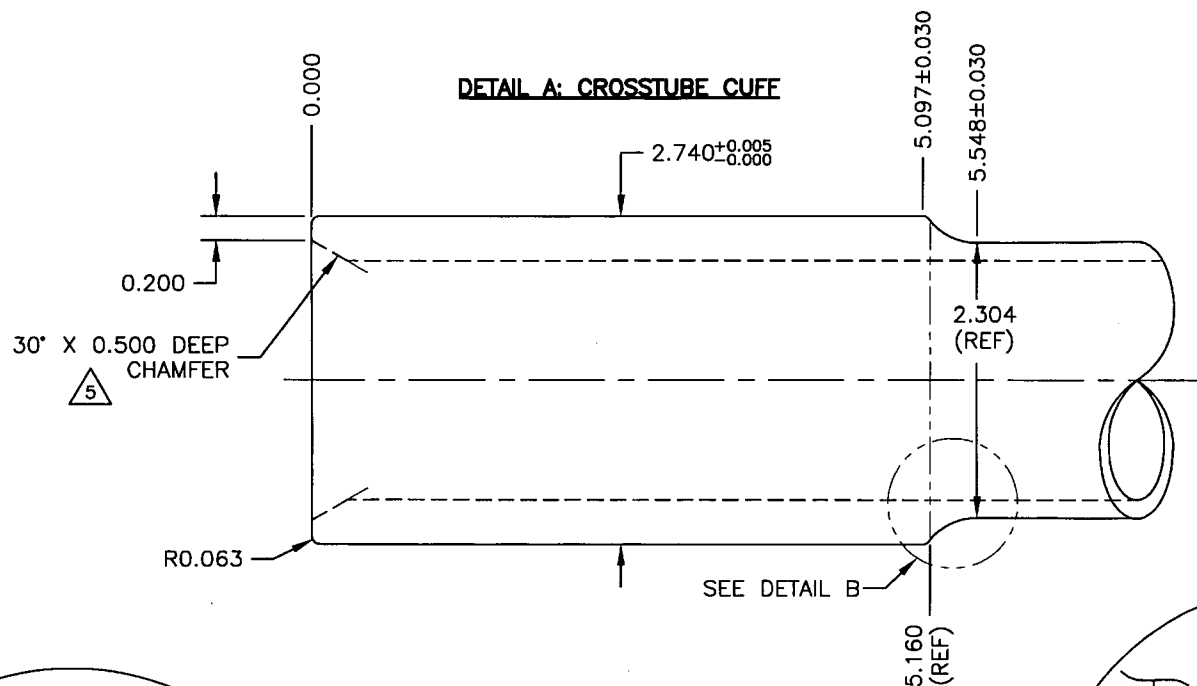
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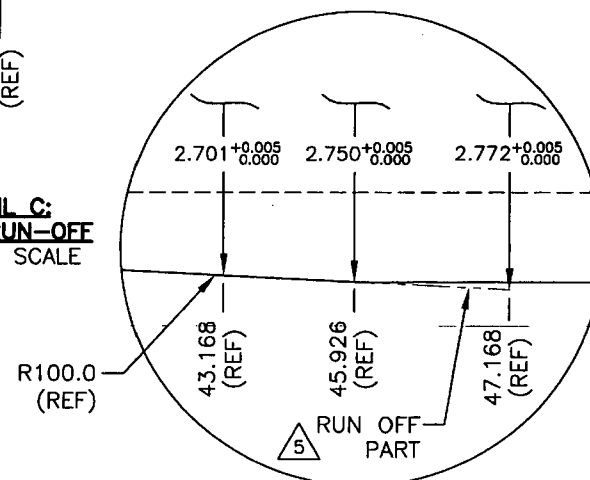
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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	9P	APPROVED	4	DRAWING NO.	REV. C
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)	D212-664-141	SHEET 2 OF 3
		SCALE	1:10		

RELEASED
 07.04.24 CP
 PER E.C.N. 883



DETAIL C: TAPER RUN-OFF
 NOT TO SCALE



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED A	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1



LIQUID PENETRANT TEST REPORT

P - 1369 1

CLIENT	DART AEROSPACE	DATE	APR 8, 2009	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1369	TIME	AM	<input type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST	PO/NO.						
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY					
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005			
PROJECT	X TUBE'S							
ITEM(S) EXAMINED	JOB #'S 46727-29, 46731, 46732							

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
PART NO. D212664101/D412664203	MATERIAL	ALODINED ALUM.	THICKNESS	
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc	
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL JAN 24 09		
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE		
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY			

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F	<input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F	<input type="checkbox"/> > 52°C/ 125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL
SURFACE ON:

212/205 HIGH FED X TUBE JOB#S 46727-29
HIGH AFT XTUBE 412 JOB#S 46731, 46732

RESULTS: NO INDICATION OF DEFECTS.
ITEMS ACCEPTABLE TO STANDARD

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E27430		
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:		
NAME (PRINT):	JASON HEWETT	NAME INITIALS		
	1 st TECHNICIAN	2 nd TECHNICIAN		
CGSB LEVEL	2	SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No	6156	CGSB REG. No		

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